

2022 CHEVROLET CORVETTE SERVICE MANUAL

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1. **Body Repair**
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Back Body Pillar Lower Reinforcement Replacement (Coupe)

Materials

- Structural Adhesive Aluminum Panel Bonding
- Structural Rivet (SR2 8X) Fastener Specifications

Removal Procedure

1. [Click here for full size](#)
2. **Warning:**

Refer to Approved Equipment for Collision Repair Warning
3. **Warning:**

Refer to Collision Sectioning Warning
4. **Warning:**

Refer to Glass and Sheet Metal Handling Warning
5. **Note:**

The back body pillar lower reinforcement is an aluminum extrusion. Aluminum
6. **Note:**

Three dimensional measuring equipment required for installation.
7. Disable the SIR system. SIR Disabling and Enabling.
8. Remove all related panels and components.
9. Remove quarter outer panel. Quarter Outer Panel Replacement - Left Side or Quarter Outer Panel Replacement - Right Side
10. Remove rear compartment panel frame. Rear Compartment Panel Frame Replacement
11. Remove load floor panel rear cross bars. Load Floor Panel Rear Cross Bar Replacement - Left Side or Load Floor Panel Rear Cross Bar Replacement - Right Side
12. Remove rear window panel reinforcement. Rear Window Panel Reinforcement Replacement
13. Remove the sealers and anti-corrosion materials from the repair area as necessary. Anti-Corrosion Treatment and Repair
14. [Click here for full size](#)
15. **Note:**

Left shown, right similar.
16. Remove flow drill screws (1). [4X] Fastener Specifications
17. [Click here for full size](#)
18. Remove flow drill screws (1). [7X] Fastener Specifications
19. [Click here for full size](#)
20. Remove flow drill screws (1). [6X] Fastener Specifications

21. [Click here for full size](#)

22. Note:

Do not damage or cut attaching panels and reinforcements.

23. Using reciprocating saw or equivalent tool cut through back body pillar lower reinforcement at marked locations (1).

24. Remove section of back body pillar lower reinforcement (2).

25. [Click here for full size](#)

26. Warning:

Refer to Aluminum Panel Warning.

27. Note:

Left shown, right similar.

28. Note:

Use even pulling strokes to control cut.

29. Note:

Do not damage or cut attaching panels and reinforcements.

30. Using belt sander or similar tool, cut through remaining portion of back body pillar lower reinforcement (1) to remove laser weld.

31. [Click here for full size](#)

32. Warning:

When separating the aluminum panels during collision repair, be sure to adhere to the following precautions:

- Do not use an open flame
- Focus heat onto panel being replaced and do not exceed 200°C (392°F) for 3 consecutive minutes
- Use care not to damage adjacent panel while prying the panels apart

Failure to follow the precautions may lead to vehicle damage or personal injury.

33. Apply heat to release adhesive (1).

34. [Click here for full size](#)

35. Note:

Left shown, right similar.

36. Apply heat to release adhesive (1).

37. [Click here for full size](#)

38. Remove remaining back body pillar lower reinforcement (1) from vehicle.

39. Note:

Do not damage body structure when removing adhesive.

40. Remove remaining adhesive from body structure.

Installation Procedure

1. [Click here for full size](#)

2. Note:

Temporarily install replacement part.

3. Position back body pillar lower reinforcement (1) on vehicle using three-dimensional measuring equipment and clamp into place.

4. [Click here for full size](#)

5. Note:

The 6.7 mm (17/64) holes are used for rivet installation.

6. Note:

Structural blind rivets in conjunction with structural adhesive will be used in place of laser welds.

7. Drill 6.7 mm (17/64) holes (1) for structural blind rivets. [8X] Fastener Specifications

8. Note:

If production screw holes (2) are in place, production flow drill screws may be reused.

9. Drill 4.0 mm (5/32) pilot holes (2) for flow drill screws (M5). [7X] Fastener Specifications

10. [Click here for full size](#)

11. Note:

Left shown, right similar.

12. Note:

If production screw holes (1) are in place, production flow drill screws may be reused.

13. Drill 4.0 mm (5/32) pilot holes (1) for flow drill screws (M5). [4X] Fastener Specifications

14. [Click here for full size](#)

15. Note:

If production screw holes (1) are in place, production flow drill screws may be reused.

16. Drill 4.0 mm (5/32) pilot holes (1) for flow drill screws (M5). [6X] Fastener Specifications

17. [Click here for full size](#)

18. Remove back body pillar lower reinforcement (1) from vehicle.

19. [Click here for full size](#)

20. Note:

Left shown, right similar.

21. Note:

Accurate and timely assembly methods must be used in order to meet proper bonding requirements.

22. Note:

Dry fit all parts with proper clamping devices prior to final assembly to ensure full understanding of the assembly process.

23. Note:

When using adhesive, ensure all necessary tools and materials are in place prior to final assembly.

24. Note:

Only remove E-coat where adhesive will be applied.

25. Note:

Ensure all bare metal is covered.

26. Clean and prepare mating surfaces on structure and replacement part according to adhesive manufacturer's recommendations. Aluminum Panel Bonding

27. Apply structural adhesive (1) to mating surfaces on structure and replacement part according to adhesive manufacturer's recommendations. Aluminum Panel Bonding

28. [Click here for full size](#)

29. Install back body pillar lower reinforcement (1) on vehicle and clamp into place.

30. [Click here for full size](#)

31. Note:

Install fasteners from direction shown.

32. Install structural rivet (1). [SR2 8X] Fastener Specifications

33. Note:

Ensure screw is fully seated with a minimum torque of 5N-m (4 lb ft) and not stripped.

34. Install flow drill screws (2). [7X] Fastener Specifications

35. [Click here for full size](#)

36. Note:

Left shown, right similar.

37. Note:

Ensure screw is fully seated with a minimum torque of 5N-m (4 lb ft) and not stripped.

38. Install flow drill screws (1). [4X] Fastener Specifications

39. [Click here for full size](#)

40. Note:

Ensure screw is fully seated with a minimum torque of 5N-m (4 lb ft) and not stripped.

41. Install flow drill screws (1). [6X] Fastener Specifications

42. Remove excess adhesive.

43. Seal structural rivets with seam sealer. Anti-Corrosion Treatment and Repair

44. Install rear window panel reinforcement. Rear Window Panel Reinforcement Replacement

45. Install load floor panel rear cross bars. Load Floor Panel Rear Cross Bar Replacement - Left Side or Load Floor Panel Rear Cross Bar Replacement - Right Side

46. Install rear compartment panel frame. Rear Compartment Panel Frame Replacement

47. Install quarter outer panel. Quarter Outer Panel Replacement - Left Side or Quarter Outer Panel Replacement - Right Side

48. Apply the sealers and anti-corrosion materials to the repair area as necessary. Anti-Corrosion Treatment and Repair

49. Seal tops of countersunk rivets before applying windshield adhesive.

50. Paint the repaired area. Basecoat/Clearcoat Paint Systems

51. Install all related panels and components.

52. Enable the SIR System. SIR Disabling and Enabling